

Date: Monday, 11/21/2005 1:17:15 PM
 User: Linda Lacelle

Process Sheet

16

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE
 Job Number : 24855
 Estimate Number : 10833
 P.O. Number : N/A Part Number : D29331
 This Issue : 11/21/2005 S.O. No. : N/A Drawing Number : D2933 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : N/A Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 12/21/2005 Qty: 4 Um: Each
 Checked & Approved By : SEE ABOVE USER & DATE
 Comment : Est: B00.06.26 New DWG rev (mpp 2069) EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: B24890

Ep 06/03/12
 Ep 06/01/14

4

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly. J.G. 06/01/14

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

Ep 06/01/15

350 06/01/15 4

pfo

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SD 06-04-13

4

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET



Ep/SD

06-04-13

4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/19
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|---|---|----------------|---------------------------|---|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06/01/15 | 2.3 | one part scrap - part must have 1.6tes drawing making and causing flange thickness (0.220" to be 0.201") to thin |  06/01/15 | Scrap and destroy and Recheck all engines. | En 06/01/15 | 2 06-01-16 |  06/01/15 | 2 06-01-16 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 1:17:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 24855

Part Number: D29331

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

Trk 06/04/17

4

| | | |
|-----|-----------------|----------------------------|
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-04-18

4

| | | |
|-----|----------------|----------------|
| 7.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-04-18

4

| | | |
|-----|-----|---|
| 8.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT

Pack 4/18 (4)

| | | |
|-----|-------------|-----------------------|
| 9.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SB 06/04/18

4

| | | |
|------|----|------------------|
| 10.0 | DC | DOCUMENT CONTROL |
|------|----|------------------|



Comment: DOCUMENT CONTROL

Inspection Level 21

LS 06/04/18 (4)

Job Completion



il dec 4/19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | |
| Description: 206 Saddle, Inboard, Left side | Part Number: | D2933-1 |
| Inspection Dwg: D2933 Rev. B | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.100 | 0.140 | | 0.118 | 0.120 | 0.121 | 0.115 | | |
| B | 0.100 | 0.140 | | 0.115 | 0.120 | 0.120 | 0.117 | | |
| C | 0.100 | 0.140 | | 0.123 | 0.122 | 0.121 | 0.120 | | |
| D | 0.210 | 0.230 | | 0.215 | 0.217 | 0.217 | 0.215 | | |
| E | 1.245 | 1.255 | | 1.248 | 1.247 | 1.247 | 1.248 | | |
| F | 1.245 | 1.255 | | 1.248 | 1.247 | 1.247 | 1.248 | | |
| G | 2.495 | 2.505 | | 2.498 | 2.498 | 2.496 | 2.497 | | |
| H | 0.510 | 0.515 | | .515 | .515 | .515 | .515 | | |
| I | 1.572 | 1.582 | | 1.577 | 1.577 | 1.576 | 1.576 | | |
| J | 2.495 | 2.505 | | 2.499 | 2.495 | 2.499 | 2.497 | | |
| K | 0.257 | 0.262 | DT8683 | 0.259 | 0.259 | 0.259 | 0.259 | | |
| L | 0.312 | 0.317 | DT8686 | 0.312 | 0.312 | 0.312 | 0.312 | | |
| M | 0.235 | 0.240 | | .239 | .239 | .239 | .239 | | |
| N | 0.100 | 0.140 | | 0.122 | 0.122 | 0.124 | 0.120 | | |
| O | 0.540 | 0.560 | | 0.547 | 0.545 | 0.547 | 0.548 | | |
| P | 0.490 | 0.510 | | 0.503 | 0.500 | 0.501 | 0.501 | | |
| Q | 3.715 | 3.725 | | 3.717 | 3.718 | 3.718 | 3.718 | | |
| R | 2.470 | 2.510 | | 2.500 | 2.500 | 2.498 | 2.501 | | |
| S | 0.240 | 0.270 | | 0.248 | 0.248 | 0.247 | 0.247 | | |
| T | 0.100 | 0.180 | | 0.140 | 0.140 | 0.140 | 0.140 | | |
| U | 1.625 | 1.635 | | 1.629 | 1.628 | 1.628 | 1.631 | | |
| V | 1.362 | 1.372 | | 1.367 | 1.367 | 1.366 | 1.367 | | |
| W | 0.316 | 0.321 | DT8690 | 0.320 | 0.320 | 0.320 | 0.320 | | |
| X | 1.125 | 1.145 | | 1.136 | 1.137 | 1.134 | 1.133 | | |
| Y | 1.565 | 1.585 | DT8695 A/B | | | | | | |
| Z | | | | | | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|-------------------|
| Measured by: | EP / SD |
| Date: | 06/01/15 06.04.13 |

| | |
|-------------|----------|
| Audited by: | JMB |
| Date: | 06/04/17 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF | |

□□□□□□□□

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

| | | | |
|-------------------|-------------------|------------------------------|----------------|
| Work Order No | : 0024855 | Department Code: | |
| Project Name | : D2933-1 | Burden Flags | : NNNNNNNN |
| Project For | : WK551 | WO Status | : Open |
| Work Order Type | : Main | Invoice State | : Not Invoiced |
| Main WO Number | : | Invoice Date | : |
| House Part Number | : D2933-1 | Invoice Number | : |
| Description | : 206 Saddle Left | Invoice Amount | : 0.00 |
| Manufactured | : Yes | | |
| Amount Req'd | : 4 | Order Entry No | : |
| Amount Done | : 0 | OE Value | : 0.00 |
| Start Date | : 11-17-05 | | |
| Est Finish Date | : 12-21-05 | Est Margin | : 0.000% |
| Act Finish Date | : | Actual Margin | : 0.000% |
| Drawings Req'd | : No | | |
| Ok for Approval | : | | |
| Approval Rec'd | : | \$0 Posted to Finished Goods | |

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | 0.00 | 0.00 | 0.00 | | |
| Production Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours | 0.00 | 0.00 | 0.00 | | |
| CNC | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | 0.00 | 0.00 | 0.00 | | |
| Misc. | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden | 0.00 | 0.00 | 0.00 | | |
| Total Cost | 0.00 | 0.00 | 0.00 | | |
| Margin | 0.000 | 0.000 | | | |
| Selling Cost | 0.00 | 0.00 | | | |

| | Estimated | Actual |
|------------------------|-----------|--------|
| Labour Hrs/Amount Done | 0.00 | 0.00 |
| Profits/(Loss) | 0.00 | 0.00 |